

Date: Thursday, 01/05/2008 9:46:04 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG			
Job Number	: 38927						
Estimate Number	: 10428						
P.O. Number				Part Number	: D32351		
This Issue	: 01/05/2008	S.O. No. :			Drawing Number	: D3235 REV A	
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: 14	Type :	MACHINED PARTS		Drawing Revision	: A	
Previous Run	: 37933			Material	:		
Written By				Due Date	: 15/05/2008		
Checked & Approved By	: <u>JUL 08-5-01</u>			Qty:	100	Um: Each	
Comment	: Est A 04.04.19 New issue KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
		Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s) Lug Extrusion D2423 extrusion Batch: <u>B33310</u>	
2.0	BAND SAW	BAND SAW	
		Comment: Band Saw Cut D2423 extrusion to 0.820" Batch: _____	<i>cut at 0.820</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 <i>Issue P.D. 6276</i>	 <i>100</i>
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA369 and Dwg D3235 2-Identify as D3235-1 3-Deburr and Tumble	<i>100</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>Receive + inspect for transit damage Ensure C of C attached</i>	 <i>100</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>100</i>
5.0	QC5	SECOND CHECK	 <i>50805/12 +100</i>
		Comment: SECOND CHECK <i>Inspect level 5</i>	<i>counts</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 38927		Part Number: D32351
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  2D/Fx 08/05/12 (100)
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
7.0	QC5 	INSPECT WORK TO CURRENT STEP  S 08/05/12 (100)
Comment: INSPECT WORK TO CURRENT STEP		
8.0	POWDER COATING 	POWDER COATING m/07550 
Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3		
START TIME: 2:40 OVEN TEMPERATURE: 321.6° FINISH TIME: 3:10		 Fx 08/05/12 (100)
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  M-F 08/05/12 (100)
Comment: INSPECT POWDER COAT		
10.0	PACKAGING 1 	PACKAGING RESOURCE #1  100X 100X
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 411		 8/5/13 SC
11.0	QC21 	FINAL INSPECTION/W/O RELEASE  08/05/14 FJ
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion		 W 08/05/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38927
Description: Mounting Lug	Part Number:	D3235-1
Inspection Dwg: D3235	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article □ Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	<i>[Signature]</i>

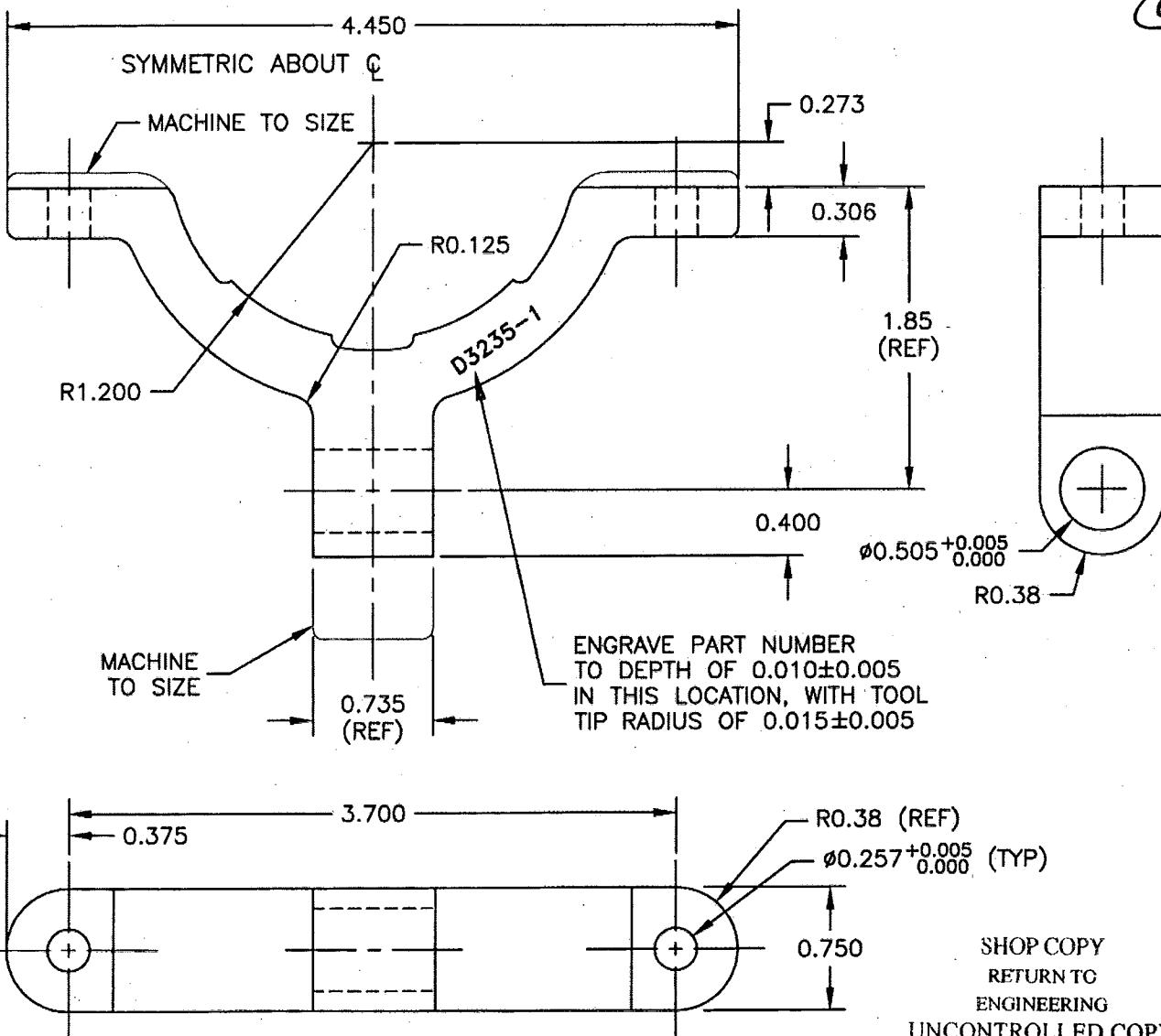


1 COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3235
DATE		REV. A SHEET 1 OF 1
04.03.02		TITLE MOUNTING LUG
		SCALE 1:1
A	04.03.02	NEW ISSUE

RELEASED
04.04.05

65



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER

NO. 38927



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D3235-1	Mounting Lug	6276

MATERIAL: Supplied by DART D2324 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink that reads "Shig Walz". The signature is fluid and cursive, with "Shig" on top and "Walz" below it, with a small flourish at the end.

Vankleek Hill, May 9, 2008